

**Amendments to the Claims**

Please amend claims 1-20. The pending claims are listed below.

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1 Claim 1 (Currently Amended): A method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 for a rotating disk drive data storage device, comprising the steps of:  
3 providing a ~~ceramic or glass~~ disk substrate having a circumferential edge, said disk  
4 substrate being of a material from the set of materials consisting of: glass, ceramic, and a  
5 combination of glass and ceramic;  
6 loading said disk substrate to an edge finishing apparatus; and  
7 grinding said circumferential edge of said disk substrate in a ductile grinding regime using  
8 said edge finishing apparatus.

1 Claim 2 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 1, wherein said disk drive data storage device is a rotating magnetic disk drive data  
3 storage device, said disk substrate being subsequently coated with a magnetic coating after said  
4 grinding step.

1 Claim 3 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 1, further comprising the step of coarse grinding said circumferential edge in a non-  
3 ductile mode, said step of coarse grinding said circumferential edge in a non-ductile mode being  
4 performed before said step of grinding said circumferential edge in a ductile grinding regime.

1 Claim 4 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 1, wherein said disk substrate contains an outer circumferential edge at the periphery  
3 thereof and a central aperture defining an inner circumferential edge, and wherein said grinding  
4 step is applied to both said outer circumferential edge of said disk substrate and to said inner  
5 circumferential edge.

6 Claim 5 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
7 of claim 1, wherein said grinding step comprises grinding said edge with a formed grinding  
8 appliance conforming to an edge radius at said circumferential edge.

1 Claim 6 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 1, wherein said grinding step comprises bringing a grinding appliance of said edge  
3 finishing apparatus in contact with said circumferential edge and providing relative motion  
4 between said grinding appliance and circumferential edge of approximately 30 m/sec or more.

1 Claim 7 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 1, wherein said edge finishing apparatus comprises a grinding appliance having diamond  
3 particles of approximately 6 microns or less.

1 Claim 8 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 1, wherein said ~~glass or ceramic~~ disk substrate is finished for installation in a disk drive  
3 data storage device without chemical strengthening of said disk substrate.

1 Claim 9 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 8, wherein said ~~glass or ceramic~~ disk substrate is of a material which is not chemically  
3 strengthenable.

1 Claim 10 (Currently Amended): A method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 for a rotating disk drive data storage device, comprising the steps of:  
3 providing an ~~ceramic or glass~~ disk substrate having a cut, unfinished circumferential edge,  
4 said disk substrate being of a material from the set of materials consisting of glass, ceramic, and a  
5 combination of glass and ceramic, wherein said ~~ceramic or glass~~ disk substrate material is not  
6 chemically strengthenable; and  
7 finishing said circumferential edge of said disk substrate to a finished state suitable for use  
8 in a disk drive data storage apparatus using at least one edge finishing apparatus.

1 Claim 11 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk  
2 substrate of claim 10, wherein said step of finishing said circumferential edge of said disk  
3 substrate comprises grinding said edge in a ductile grinding regime.

1 Claim 12 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 10, wherein said disk drive data storage device is a rotating magnetic disk drive data  
3 storage device, said method further comprising the step of coating at least one flat surface of said  
4 disk substrate with a magnetic coating, said coating step being performed after said grinding step.

1 Claim 13 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 10, wherein said disk substrate contains an outer circumferential edge at the periphery  
3 thereof and a central aperture defining an inner circumferential edge, and wherein said finishing  
4 step comprises finishing both said outer circumferential edge of said disk substrate and said inner  
5 circumferential edge.

1 Claim 14 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 10, wherein said step of finishing said circumferential edge grinding step comprises  
3 forming an edge radius at said circumferential edge.

4 Claim 15 (Currently Amended): A method for manufacturing a ~~glass or ceramic~~ disk substrate  
5 for a rotating disk drive data storage device, comprising the steps of:

6 providing a ~~ceramic or glass~~ disk substrate having a cut, unfinished circumferential edge,  
7 said disk substrate being of a material from the set of materials consisting of glass, ceramic, and a  
8 combination of glass and ceramic;

9 finishing said circumferential edge of said disk substrate to a finished state suitable for use  
10 in a disk drive data storage apparatus by application of mechanical forces using at least one edge  
11 finishing apparatus, said finishing step being accomplished without chemical strengthening of  
12 said ~~glass~~ disk substrate.

1 Claim 16 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 15, wherein said disk substrate is of a material which is not chemically strengthenable.

1 Claim 17 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 15, wherein said step of finishing said circumferential edge of said disk substrate  
3 comprises grinding said edge in a ductile grinding regime.

1 Claim 18 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 15, wherein said disk drive data storage device is a rotating magnetic disk drive data  
3 storage device, said method further comprising the step of coating at least one flat surface of said  
4 disk substrate with a magnetic coating, said coating step being performed after said grinding step.

1 Claim 19 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
2 of claim 15, wherein said disk substrate contains an outer circumferential edge at the periphery  
3 thereof and a central aperture defining an inner circumferential edge, and wherein said finishing  
4 step comprises finishing both said outer circumferential edge of said disk substrate and said inner  
5 circumferential edge.

- 6 Claim 20 (Currently Amended): The method for manufacturing a ~~glass or ceramic~~ disk substrate  
7 of claim 15, wherein said step of finishing said circumferential edge grinding step comprises  
8 forming an edge radius at said circumferential edge.

Claims 21-43 (Cancelled)

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